

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011716**Date Inspected:** 27-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10449 (for ZPMC UT Reject) of 10TR1-010; Weld 014. Welder is identified as 201215. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10455 (for ZPMC UT Reject) of 10TR2-014; Weld 014. Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) of 20TR2-004; Weld 015. Welder is identified as 051356. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-001; Weld 015. Welder is identified as 051356. ZPMC Quality

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Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-007; Weld 015. Welder is identified as 044830. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-015; Weld 011. Welder is identified as 044790. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

This QA Inspector observed Magnetic Particle Testing being performed by ZPMC MT Technician Jin Jian Ting of LD3021-001. 16 welds tested with 14 rejects report by the ZPMC MT Technician as follows:

1. Weld 36; MT Reject; Y=50mm; Requires CWR
2. Weld 36; MT Reject; Y=1250mm; Requires CWR
3. Weld 37; MT Reject; Y=30mm; Requires CWR
4. Weld 43; MT Reject; Y=50mm; Requires CWR
5. Weld 43; MT Reject; Y=1270mm; Requires CWR
6. Weld 44; MT Reject; Y=1230mm; Requires CWR
7. Weld 56; MT Reject; Y=30mm; Requires CWR
8. Weld 57; MT Reject; Y=480mm; Requires CWR
9. Weld 64; MT Reject; Y=1270mm; Requires CWR
10. Weld 71; MT Reject; Y=1280mm; Requires CWR
11. Weld 77; MT Reject; Y=0mm; Requires CWR
12. Weld 78; MT Reject; Y=600mm; Requires CWR
13. Weld 85; MT Reject; Y=20mm; Requires CWR
14. Weld 85; MT Reject; Y=1280mm; Requires CWR

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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